



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D105-674-011
Job Sheet 179142



Part No: D105-674-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH, Matte Black



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 7/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.07.07 New IssueKJ/JLM IPP revB 10.02.22 per PAR 09-043 EC verified by: DD
IPP Rev C 10.09.17 added D2966-1-bent EC verified by DD IPP REV:D 13.04.08 AS PER ECN 13-510 DD
VERF:JLM IPP REV:E 14.02.05 as per dwg D2966 rev.b DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/23/18	7/23/18	0.00	0.00	Start Up Skidtubes-1		BR
130	Skidtubes	1 pcs	7/23/18	7/23/18	0.00	3.30	Skidtubes-1		BE
140	Skidtubes	1 pcs	7/23/18	7/23/18	0.00	3.30	Skidtubes-1		BE
150	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC5		BE DAS
160	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC10		38 DAS
170	HandFinish	1 pcs	7/23/18	7/23/18	0.00	0.93	HandFinish1		SA 18-07-18
180	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC7-1		BE
190	Skidtubes	1 pcs	7/23/18	7/23/18	0.00	1.56	Skidtubes-1		BE 14
200	Skidtubes	1 pcs	7/23/18	7/23/18	0.00	1.56	Skidtubes-1		DAS BE
210	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC10		38 DAS
220	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC5		9-89 38
225	HandFinish	1 pcs	7/23/18	7/23/18	0.00	0.93	HandFinish2		SA 18-07-18
230	SprayPaint	1 pcs	7/23/18	7/23/18	0.00	2.63	Spray Paint		MD
240	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC14		18-7-20
250	HandFinish	1 pcs	7/23/18	7/23/18	0.00	0.93	HandFinish3		MD 18-7-20
260	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC3		38 DAS
270	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC5		9-89 38
280	Packaging	1 pcs	7/23/18	7/23/18	0.00	0.00	Packaging1-1		JUL 30 2018
290	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC4		MD
295	DC	1 pcs	7/23/18	7/23/18	0.00	0.00	DC		DAS 53
300	Packaging	1 pcs	7/23/18	7/23/18	0.00	0.00	Packaging3-1		JUL 30 2018
310	QC21-FG	1 Ea	7/23/18	7/23/18	0.00	0.00	QC21		9-89

Part Op 130 - ** Pull D2966-1bent ** 0 1- Cut Aft end as per dwg, remove pending marks and deburr ends. Scribe batch#. 2- Drill Descriptions: Aft Cap holes using DT8678, do not open to finished size. 3- Locate from aft caps pilot holes, install DT9982 pilot drill all crossbolt holes. 4- Clamp DT8679 to the tube. Drill all wearplate holes to 0.297". Open two side holes (1 per side) located at 8.89" from aft to 0.297". Deburr. 5- Open Aft Cap holes as per dwg 6- Two most fwd crossbolt holes must be laid out manually. ** VERIFY MEASUREMENTS BEFORE DRILLING. USING DT9937 AND DT9938

A/R
138834

140 - 1- Weld Fwd Cap as per Dwg D2966 and QSI 004. 2- Grind FWD cap welds flush. A/R 138834

190 - 1- Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966 2- Deburr holes inside & outside, blow out chips

200 - 1-Bond Web in place per QSI 015. (Ensure holes line up) Pick: A/R Sikaflex Batch: 138874 Exp: MAR 06 2019

225 - Re-alodine tube as per QSI 005 section 4.1.2.1 (Do not acid etch.)

230 - *****Install insert/ screw/ washer in two place as per (NOTE 11) dwg D2966***** PRIME AS PER DWG (REF.

4.2.1.3.2) A/R PRIMER BATCH: PAINT MATTE BLACK AS PER DWG (REF. QSI 005 4.3) A/R PAINT

Fig. sold
L 0
107.1

2ART
AEROSPACE

Work Order update only

[illegible]

BATCH:

250 - 1-Inspect for foreign objects as per QSI 024 2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side Pick:

270 - *****ENSURE INSERTS ARE AT LOCATION (6) AS PER DWG D2966*****

295 - Photocopy bluefile & type labels per PPP D105-674-011 CHG004

300 - Identify and pack for shipping as per PPP D105-674-011 Location: FG071

Job BOM

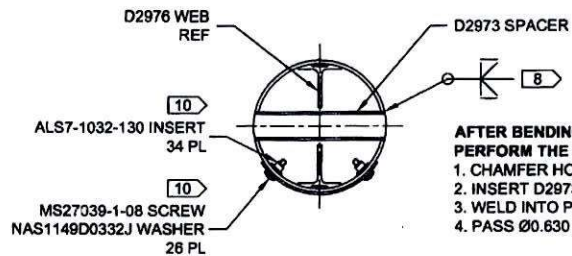
Part / Item	Component Name	Quantity	Operation	Container
D2966-1-BENT	Skidtube Assembly 105	1 Ea (1 ea)	90-Start up Operation	810727
D2964	Cap	1 Ea (1 ea)	140-Skidtubes	5043522
D2971	Cross Bolt Spacer	1 Ea (1 ea)	200-Skidtubes	F155918
D2973	Cross Bolt Spacer	7 Ea (7 ea)	200-Skidtubes	F144627
D2976	BO 105 Skidtube I-Beam	1 Ea (1 ea)	200-Skidtubes	813130
ALS7-1032-130	Rivnut	36 Ea (36 ea)	250-HandFinish	5084123
D2965	Cap	1 Ea (1 ea)	250-HandFinish	5096636
D2970-1	Wearplate Fwd	1 Ea (1 ea)	250-HandFinish	F158226
D2970-3	Wearplate Center	1 Ea (1 ea)	250-HandFinish	F128917
D3176-1	Bushing	1 Ea (1 ea)	250-HandFinish	F145511
D3176-3	Nut	1 Ea (1 ea)	250-HandFinish	F108638
MS27039-1-08	Screw	26 Ea (26 ea)	250-HandFinish	5043210
MS27039-1-09	Screw	2 Ea (2 ea)	250-HandFinish	5035296
NAS1149D0332J	Washer	28 Ea (28 ea)	250-HandFinish	F180571
AN4-51A	Bolt	3 Ea (3 ea)	280-Packaging	3053944
D2972	Bushing	6 Ea (6 ea)	280-Packaging	F110766
D2974	Packer Wearplate Aft	1 Ea (1 ea)	280-Packaging	F126270
D2975	Wearplate	2 Ea (2 ea)	280-Packaging	F158463
MS21042L4	Nut	3 Ea (3 ea)	280-Packaging	5089365
MS27039-1-08	Screw	8 Ea (8 ea)	280-Packaging	5020602
NAS1149D0332J	Washer	8 Ea (8 ea)	280-Packaging	5038396

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2966-1-BENT	1	2	0
140-Skidtubes	D2964	1	15	0
200-Skidtubes	D2971	1	4	0
	D2973	7	32	0
	D2976	1	12	0
250-HandFinish	ALS7-1032-130	36	1,467	0
	D2965	1	82	0
	D2970-1	1	2	0
	D2970-3	1	11	0
	D3176-1	1	14	0
	D3176-3	1	15	0
	MS27039-1-08	26	386	0
	MS27039-1-09	2	150	0
	NAS1149D0332J	28	1,810	0
280-Packaging	AN4-51A	3	182	0
	D2972	6	7	0
	D2974	1	9	0
	D2975	2	6	0
	MS21042L4	3	2,710	0
	MS27039-1-08	8	386	0
	NAS1149D0332J	8	1,810	0

Part Specifications

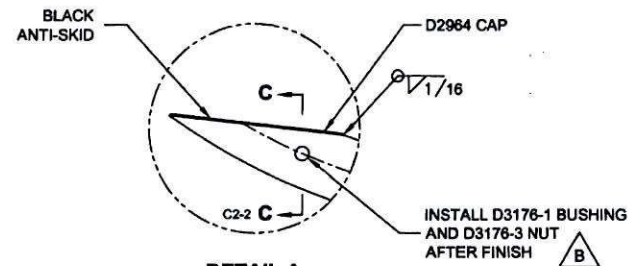
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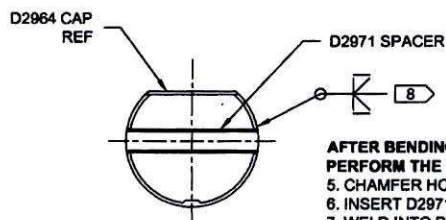
**AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:**

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2973 SPACER, 7 PL
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.630 DRILL TO REMOVE SPILL OVER

SECTION B-B
SCALE 6X



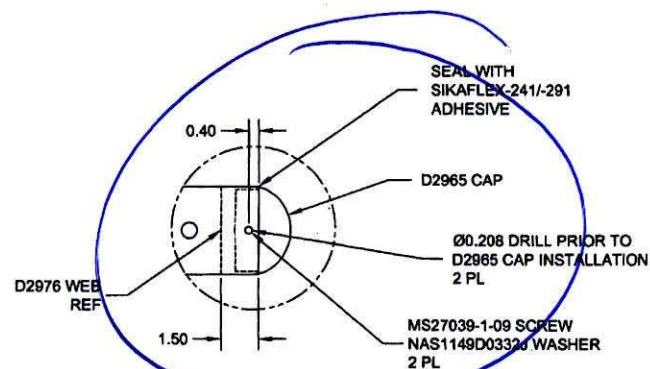
DETAIL A
SCALE 6X



**AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.875 HOLES ONLY:**

5. CHAMFER HOLE 0.030 x 45°
6. INSERT D2971 SPACER
7. WELD INTO PLACE AND GRIND FLUSH
8. PASS Ø0.750 DRILL TO REMOVE SPILL OVER

SECTION C-C
SCALE 6X



DETAIL D
SCALE 4X

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC
DRAWN	<i>[Signature]</i>	KENT, WA
CHECKED	<i>[Signature]</i>	DRAWING NO. D2966
MFG. APPR.	<i>[Signature]</i>	REV. B SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE BO 105 SKIDTUBE ASSEMBLY
DE APPR.	<i>[Signature]</i>	SCALE NTS
DATE	13.12.02	COPYRIGHT © 2000 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC

RELEASED
2014-02-03

ITEM	QTY	PART NUMBER	DESCRIPTION
	-041		
	X	D2966-041	SKIDTUBE ASSEMBLY
1	1	D2966-1	TUBE
2	1	D2964	CAP
3	1	D2965	CAP
4	1	D2970-1	WEARPLATE
5	1	D2970-3	WEARPLATE
6	1	D2971	CROSS BOLT SPACER
7	7	D2973	CROSS BOLT SPACER
8	1	D2976	WEB
9	1	D3176-1	BUSHING
10	1	D3176-3	NUT
11	36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
12	28	MS27039-1-08	SCREW
13	2	MS27039-1-09	SCREW
14	28	NAS1149D0332J	WASHER

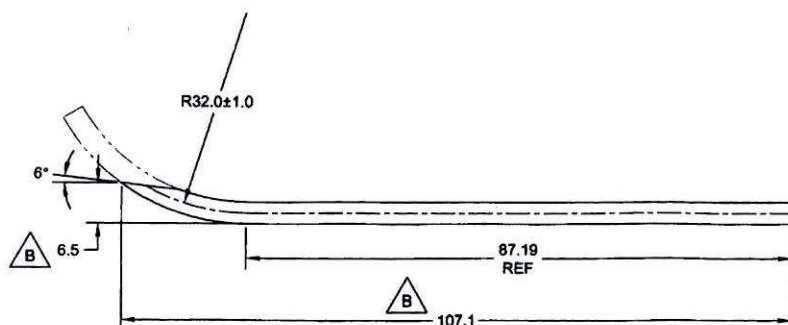
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03 2016-02-03

NOTES:

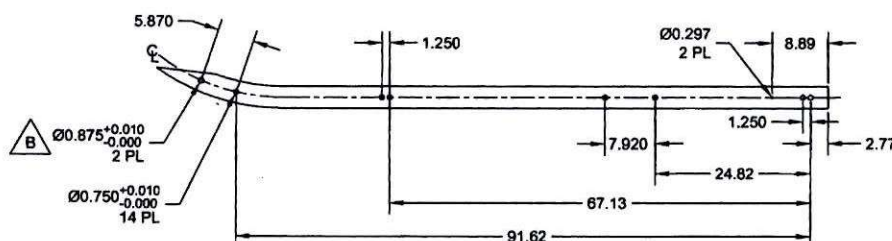
- 1) MATERIAL: MAKE D2966-1 FROM D2962-125 EXTRUSION (INITIAL LENGTH = 125.0)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB. STANDARD: PRIME (REF. 4.2.1.3.2) AND PAINT MATTE BLACK PER DART QSI 005 4.2. OPTIONAL: POWDER COAT BLACK SANDEX (REF. 4.3.5.7) PER DART QSI 005 4.3. OPTIONAL: BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS STATED OTHERWISE
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 18 lb
- 8) WELDING: PER DART QSI 004
- 9) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 10) INSTALL ALS7-1032-130 AFTER FINISH PER SECTION B-B (34 PLACES). DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 11) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND NAS1149D0332J WASHER IN 2 PLACES THIS LOCATION BEFORE PRIME AND PAINT (OR POWDER COATING).
- 12) DO NOT INSTALL MS27039-1-08 SCREWS AND NAS1149D0332J WASHERS IN THESE LOCATIONS.

B	UPDATE TO CURRENT STD; INCORP. REV. A1 AND A2: CHG COLOR TO BLACK SANDEX (ZN C3-1) AND ADD D3176-1/-3 (ZN D3-1, C1-2). PRIME AND PAINT NOW STD WHILE POWDER COAT IS OPTIONAL (ZN C3-1); Ø0.875 WAS Ø0.750 (ZN B52-1), Ø0.750 WAS Ø0.630 (ZN B6-2); TOL CHG (ZN D8-1 AND D6-1).	MB	13.12.02
A	NEW ISSUE	RF	00.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D2966	SHEET 1 OF
APPROVED		TITLE	SCALE
DE APPR.		BO 105 SKIDTUBE ASSEMBLY	NT
DATE	13.12.02	COPYRIGHT © 2000 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

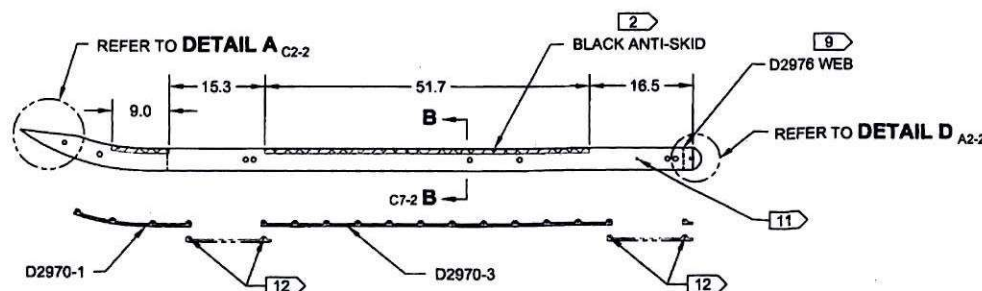
D2966-1 BENDING/CUTTING DETAIL
(MAKE FROM D2962-125 EXTRUSION)



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



105 Skid Black Sand.